

Date: Monday, 11/6/2006 2:40:36 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RING		
Job Number	: 29353B					
Estimate Number	: 10395					
P.O. Number	: N/A		Part Number	: D29685		
This Issue	: 11/6/2006	S.O. No. : N/A	Drawing Number	: D2968		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B1		
Previous Run	: 28865B		Material	: N/A		
Written By	:		Due Date	: 11/30/2006		
Checked & Approved By	: <u>gj</u> 06/11/07		Qty:	30	Um:	Each
Comment	: Est:C 03.04.11 Reformat; Incorporated D2968-1/5 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W 
		
	Comment: Qty.: 0.0587 f(s)/Unit Total : 1.7609 f(s) Material: AISI 4130 Ø 3.00 .500" WALL " Bar (M4130N-R0.750) Identify AS D2968-1	361 Batch: M102020 <i>9ml 06/11/13</i>
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE 
		
	Comment: MORI SEIKI LATHE 1-Turn Blank as per Folio FA049 and Dwg D2968 2-Deburr, no sharp edges	<i>9ml 06/11/13</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>9ml 06/11/13</i>
4.0	QC8	SECOND CHECK 
		
	Comment: SECOND CHECK	<i>J.L 06/11/13</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST396	<i>PV 8/11/15 (50)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:40:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 29353B

Part Number: D29685

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(53)

Comment: FINAL INSPECTION/W/O RELEASE

Do 6/11/16

Job Completion



U Da 11/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

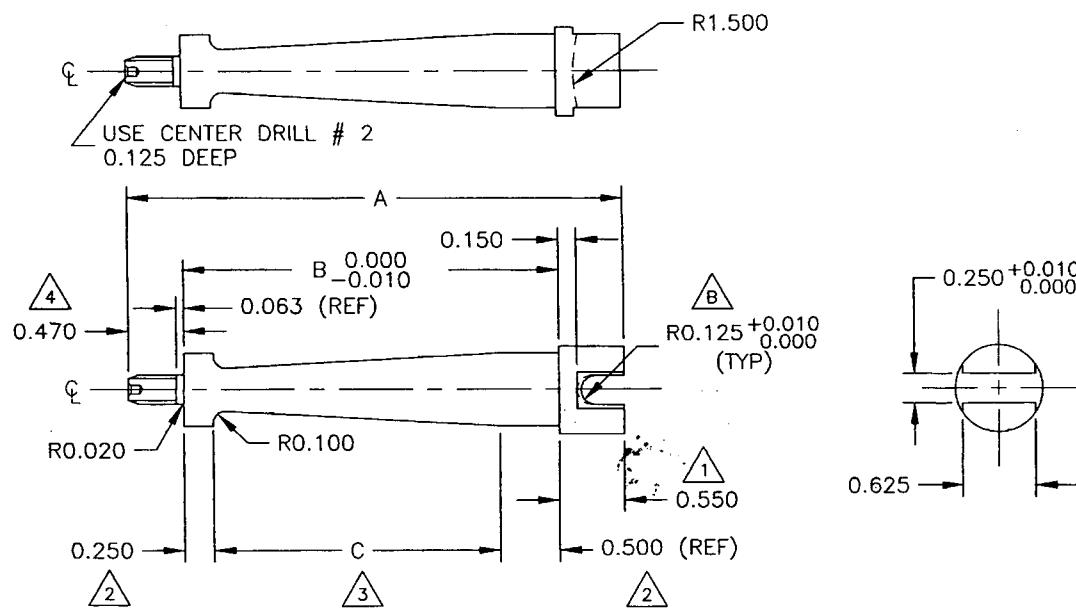
DART AEROSPACE LTD	Work Order:	29353B
Description: Tow Ring	Part Number:	D2968-5
Inspection Dwg: D2968	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>mk</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	06/11/12	Date:	06/11/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	P/O D2968-041/-043	KJ/RF <i>[initials]</i> <i>[initials]</i>



D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

1 00.750 Q.D.

2 00.625 Q.D.

**MACHINE UNIFORM TAPER FROM Ø0.363 O.D.
TO Ø0.625 O.D.**

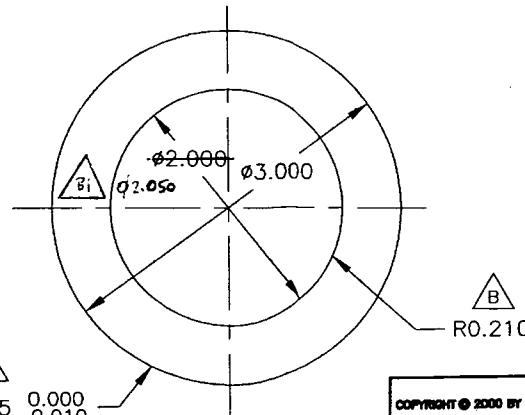
**⚠ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED**

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

D2968-5 RING

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

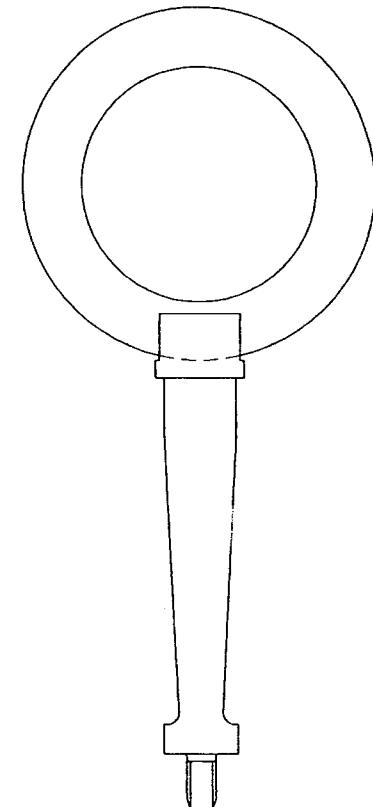


D2968-5 RING

12
115-
RE CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN		DRAWN BY DART MARKHAM, ONTARIO, CANADA
CHECKED		APPROVED
DATE 00.05.31		DRAWING NO. D2968
		REV. B SHEET 1 OF 1
AND CONFIDENTIAL EXpress CONDITION ED FOR ANY PURPOSE TED TO ANY OTHER PERMISSION FROM		TITLE TOW RING
		SCALE 1:



D2968-5 RIN

1 /

RELEASED
20-04-04 8:00

UNDER REVIEW

USE 2968-1 STEM

FOR -041
USE 2968-3 STEM
FOR -041